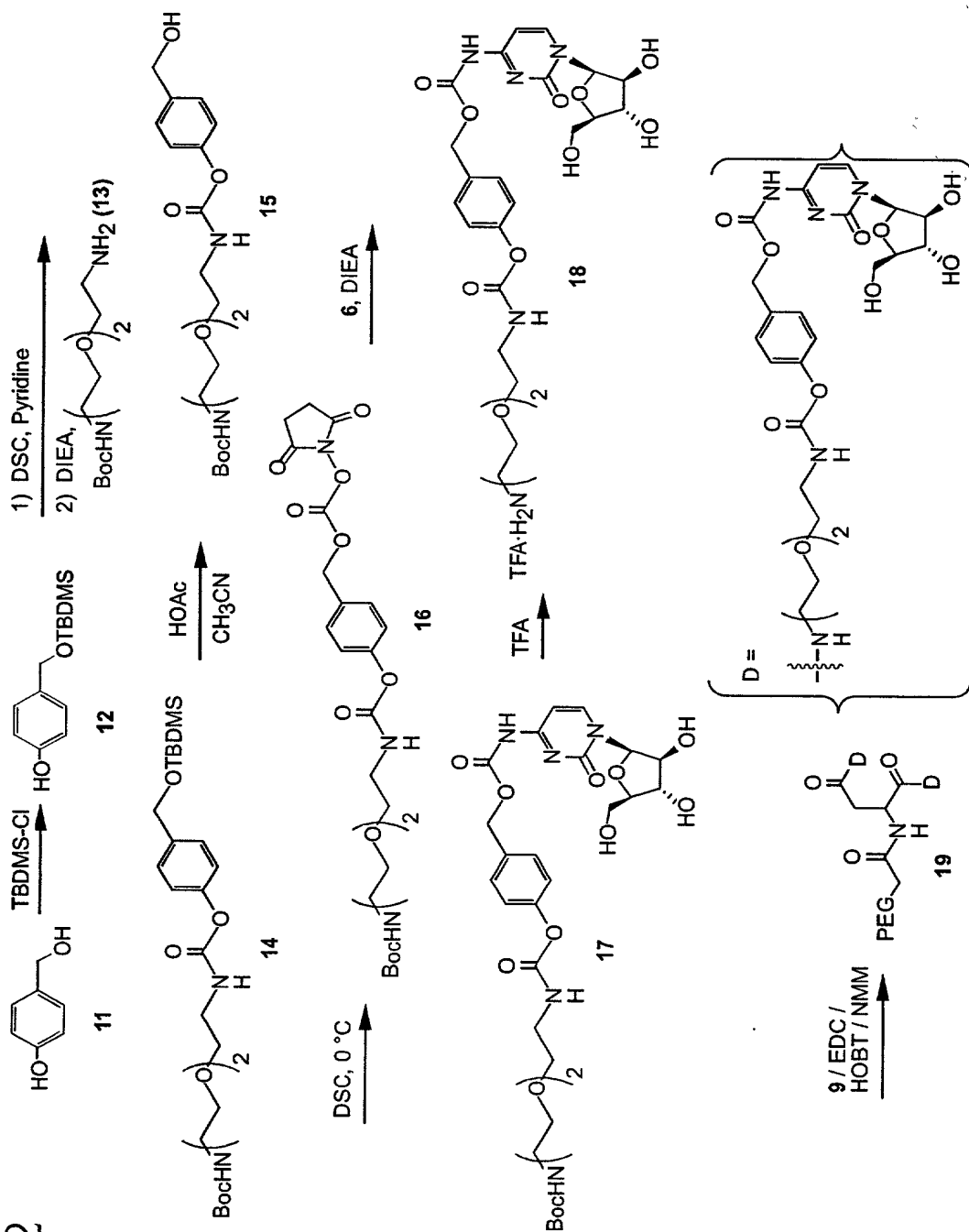


FIG. 2



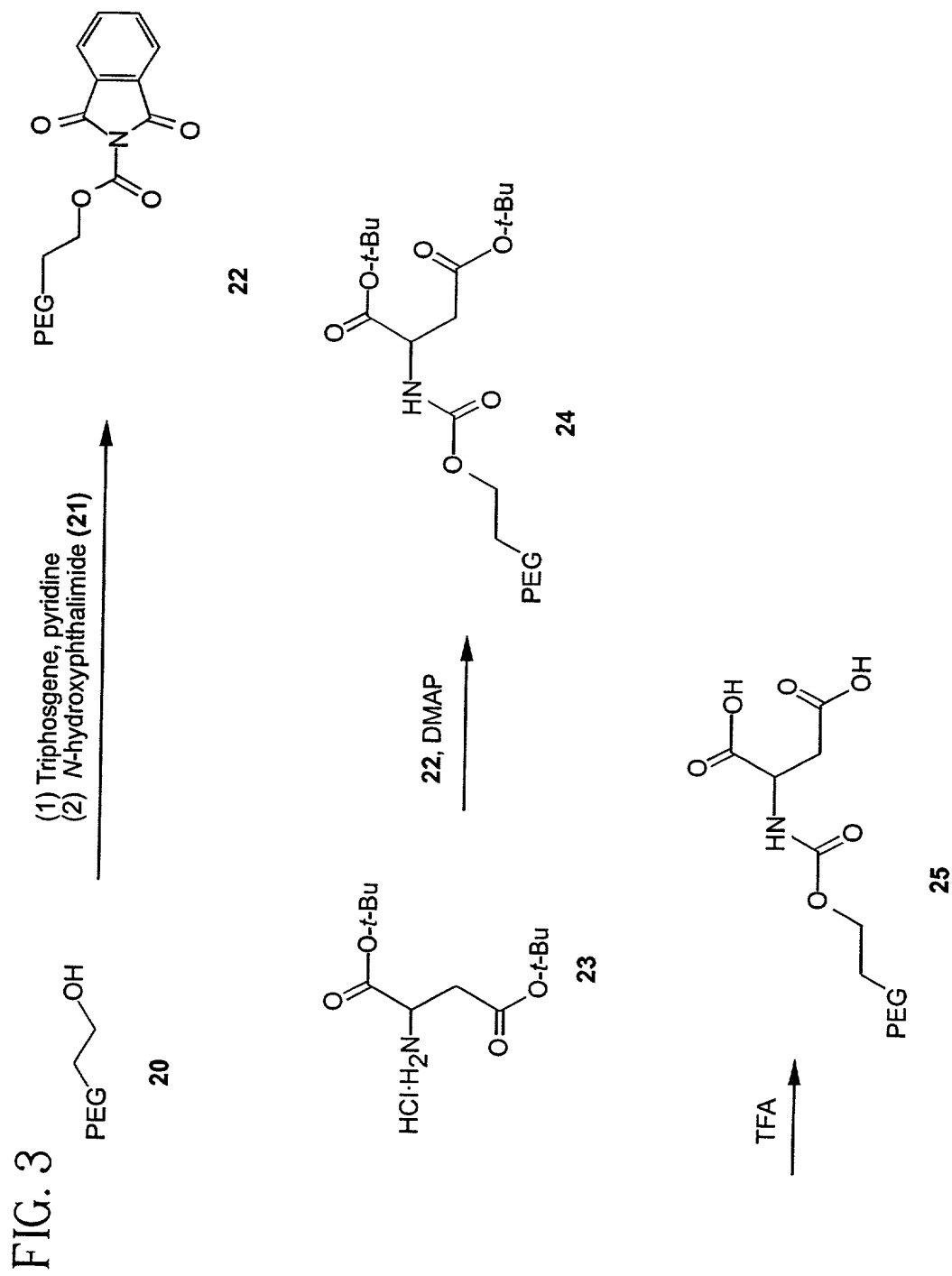


FIG. 4

Chemical reaction scheme showing the synthesis of compound 30 from Melphalan (26).

Melphalan (26) reacts with HCl , 2,2-dimethoxypropane, and MeOH to form compound 27.

Compound 27 reacts with TFA to form compound 28.

Compound 28 reacts with 25/EDC and DMAP to form compound 29.

Compound 29 reacts with a PEG linker and a deuterated amino acid derivative to form compound 30.

Structure 30 is a conjugate consisting of a PEG chain, a deuterated amino acid, and a melphalan derivative.

FIG. 5

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